



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-4-2
Job Sheet 173600



Part No: C3-4-2

Job Qty: 10 ea

Part Name: Trunnion



Part Weight: 0 lbs

Job Created: 3/5/18

Due Date: 3/16/18

Type: Stock

Note: DWG C3-4-4A/C3-4-4KA Rev 10 IPP Rev A 18.03.02 New issue DP Verify DD

Ship Via: C3-4-2 Rev C

Status: Scheduled

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	10 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Machining-4		JB 18-09-19
120	CNC Lathe	10 pcs	3/15/18	3/15/18	1.50	1.25	MORI SL-154		JB 18-09-19
130	QC	10 pcs	3/15/18	3/15/18	0.00	0.00	QC2 Machining-5		JB 18-09-19
140	Mill Conv	10 pcs	3/16/18	3/16/18	0.50	1.00	Mill Conv 2		
150	QC	10 pcs	3/16/18	3/16/18	0.00	0.00	QC2 Machining-5		
160	QC	10 pcs	3/16/18	3/16/18	0.00	0.00	QC8 Machining-5		K.P 18-09-19
170	Outsource	10 pcs	3/16/18	3/16/18	0.00	0.00	Outsource1		
180	Packaging	10 pcs	3/16/18	3/16/18	0.00	0.00	Packaging2		
190	QC	10 pcs	3/16/18	3/16/18	0.00	0.00	QC6		
200	Packaging	10 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3-2		
210	QC21-SA	10 Ea	3/16/18	3/16/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FB 956 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 140 - 1-Machine as DWG 2-Debur
170 - 1--Issue P/O to Metcore ; P/O _____ RC 42-46 2-Bead blast 3- Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R1.000	4140 round bar 1.00	1.5500 ft (.155 ea)	90-Start up Operation	5070822

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R1.000	3	4	0

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ifications

ould not be found.

Plex 3/5/18 1:41 PM Dart.lajeunesse.marie

Machine To MATCH
HAD BEAMS THAT HAVE
EEN PLATED



Container No: S111385



Part: C3-4-2
Job No: 173600
Serial No/Batch: S111385
Revision: 6
Inspector:
Exp Date:
Instructions:

Date: 09/19/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

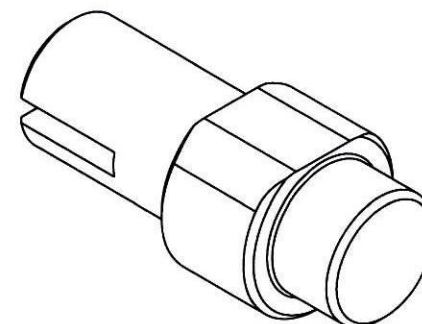
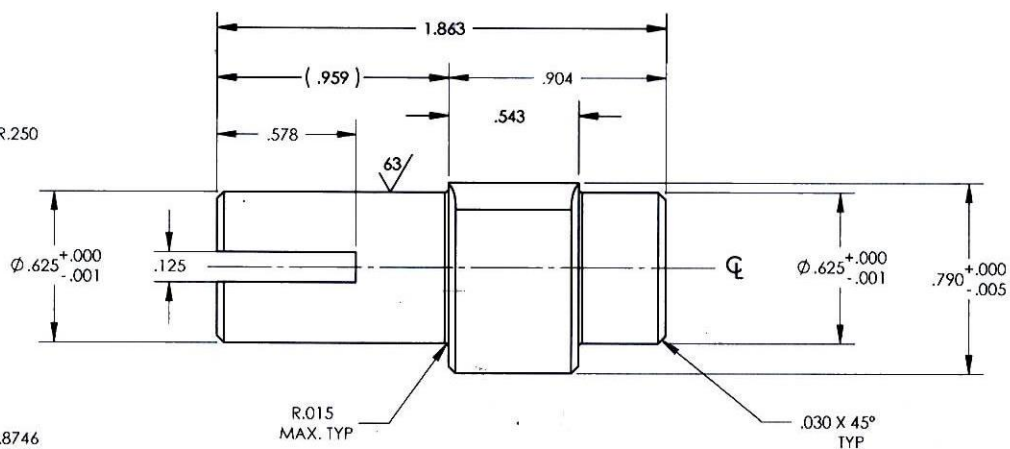
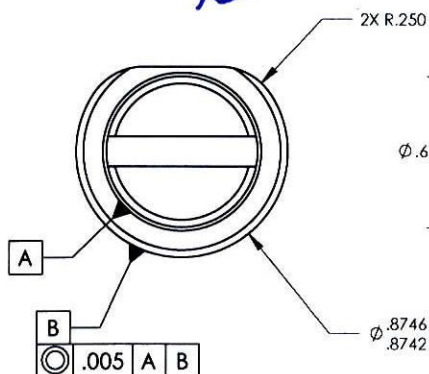
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVAL
6	CARD DIMENSIONS FROM R 471 + 0.000 - 0.005, 1Q @ 874k - 874Z, CARD TOLERANCE FOR R 790 + 0.000 TO 8 790 + 0.000 / 0.00	8/9/2012	FJC	10

20180501



NOTE:
NICKEL PLATE AFTER PART HAS BEEN
ASSEMBLED WITH LOAD BEAM C3-4-4.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			4-2	1	TRUNNION	4140 Q&T	Ø7/8" X 2	

 RED BARN MACHINE	
TRUNNION	
TITLE _____	
ENGR NO. _____	
C3-4-2	
MATL: 4140 Q&T	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XUX 2 .005 .XJX .01 .XKX .1	FRACTIONS & 1/32 ANGLES ±5°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LINES APPLY AFTER PLATING	
SCALE 2:1	DATE 10/31/2001
DRAWN BY: APICAL INDUSTRIES APPROVED <i>D. Weil</i> GREAT FINISH NICKEL PLATE SPEC _____ USED ON MODEL _____	
SHEET 1 OF 1	

INSPECTION SHEET

DAS
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9-89Date:Revised by